

5/29  
DART AEROSPACE LTD

Work Order: 23625

Description: Bracket Assembly

Part Number: D2803-041

Dwg: D2803 Rev. B

Qty: 10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	OF	05.06.21	10
2	GA	Press D2805-1 into arm as per Dwg D2803 Pick: Qty Part Number Description Batch			
		1 D2803-1 Bracket B23635			
		1 D2805-1 Stop B14243			
		1 D2809 Bushing B22529			
			SAW	05/08/31	10
3	QC5	Inspect work to Step 2	2	05.05.14	10
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05.09.22	10
5	QC3	Inspect Powder Coat	ML	05.09.22	10
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/09/26	10
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 Pick: Qty Part Number Description Batch			
		2 AN3C16A Bolt (5) M17528 (10) M17185 M17944			
		2 MS21043-3 Nut M17239			
		4 NAS1515H3 Washer M17944			
		A/R LPS-3 Corrosion Spray M17395			
8	GA	Assemble as per Dwg D2803.	SB	05/09/26	10
9	QC5	Inspect work to Step 8	2	05.05.28	10
10	ST	Identify and Stock	CD	05/10/05	10
11	AC	Cost / part: 79.51	SAW	05.10.06	10
12	DC	Close W/O 79.19 Inspect Level 21	CD	05/10/06	10

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	<i>JLM</i>
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

RELEASED  
R 05.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

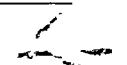
NCR: Yes

 NoDQA: 

Date: 05/05/06

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: 

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023625  
 Project Name : D2803-041  
 Project For : WK529  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2803-041  
 Description : Bracket Assembly  
 Manufactured : Yes  
 Amount Req'd : 10  
 Amount Done : 0  
 Start Date : 06-20-05  
 Est Finish Date : 07-21-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLED COPY

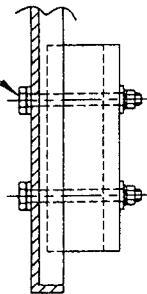


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2803
DATE	04.11.22	TITLE STA 84 BRACKET

REV. B  
SHEET 2 OF 2  
SCALE  
1:3

REFERENCE ONLY

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)

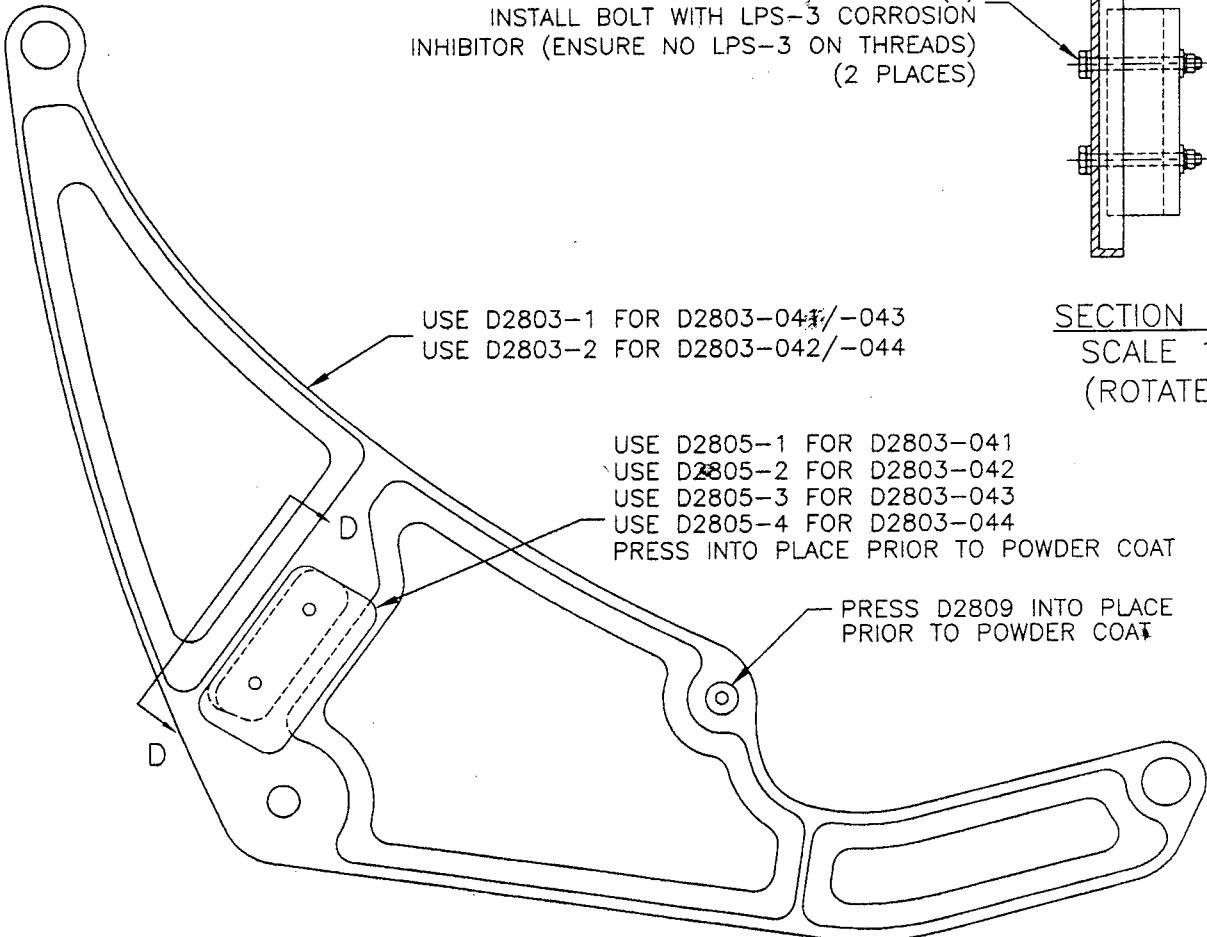


USE D2803-1 FOR D2803-041/-043  
USE D2803-2 FOR D2803-042/-044

SECTION D-D  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT



RELEASED

05-03-01

D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.